

Page 1

Insp.

Stamp

Wednesday, June 15, 2011 2:27:53 PM Item ID: D3405-041 Accept Setup Start Revision ID: Stop Item Name: Lug Assembly Start Qty: 12.00 Start Date: 6/15/2011 Cust Item ID: Required Date: 6/22/2011 Reg'd Qty: 12.00 Customer: Reference: Run Start Date: 1/06-19 Tooling: Process Plan: Approvals: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Tool ID Set Up/ Reject Tool # Plan Accept Reject Work Center ID Description Oty Run Hours Code Qty Number Draw Nbr Revision Nbr D3405 Rev B 100 0.00 FLOW WATER JET 1311-6-16 Waterjet 0.00 Memo FLOW CNC Waterjet 1-Cut as per Dwg D3405 304.175 Prog Rev: 2-Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 1311-6-16 0.00 Memo Quality Control

120

QC8- Inspect parts - second check

0.00 8 while/16

Quality Control

Memo

W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAP	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	::	PAR #:	Fault Categ	jory:	NCR: Yes	No DC	A:	_ Date: _	
	Re	solution:	Disposition	1:	QA: N/C	Closed: _		Date: _	
NCR:		-41	WORK ORDE	R NON-CONFORMA	ANCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section			ication	Approval	Approval
DAIL	SIL	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat		tion C	Chief Eng	QC Inspector

## Work Order ID 70820

Wednesday, June 15, 2011 2:27:53 PM

Item ID:

D3405-041

Revision ID: Item Name:

Lug Assembly

Start Date:

6/15/2011

Start Oty: 12.00

Req'd Qty: 12.00



Accept



Setup Start



Stop

Required Date: 6/22/2011



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Tool #

Plan

Code

Start Run

Stop



QC:

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Reject

Qty

Reject Insp. Stamp Number

Sequence ID/ Work Center ID

Brake NC

Brake NC

Description

Operation

NC BRAKE

Memo 1-Deburr

Memo

2-Form using DT8204 as per Dwg D3405 3- use DT9681 to check if correct forming 0.00

0.00

St 11/06/17

140

**Quality Control** 

OC5- Inspect part completeness to step on W/O

Accept

Qty

150

Large Fab

Large Fab

Large Fab

Memo

Weld as per Dwg D3405 use DT8484

Identify as D3405-041

0.00

0.00

B 11-7-18 (XZ

W/O:			WO	RK ORDER CHANGI	ES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		199							
Part No		PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A:	Date:	
	Resolution:			:	QA: N/C C	losed:		Date: _	
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## Work Order ID 70820

Wednesday, June 15, 2011 2:27:53 PM

Item ID:

D3405-041

Revision ID:

Item Name:

Lug Assembly

Start Date:

6/15/2011

Start Qty: 12.00

Required Date: 6/22/2011

Req'd Qty: 12.00



Accept



Setup Start



Stop

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

QC:

Date: Date: Tooling:

SPC (Y/N):

Date:

Date:

Start Run

Stop



Sequence ID/ Work Center ID

QC

Quality Control

Operation Description

QC9- Inspect visual per QSI004- Fusion Welds

Memo

Set Up/ Run Hours

0.00

Tool ID

Plan Tool# Code

Accept Qty

Reject Qty

Number

Insp. Stamp

0.00

GC11.07:14

Quality Control

QC5- Inspect part completeness to step on W/O

0.00



Powder Coating

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

Memo

Memo

START TIME: OVEN TEMPERATUR FINISH TIME:

0.00

0.00

7 16/ 11-9-15.

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	Res	colution:	Disposition	:	QA: N/C CI	osed:		_ Date: _	
NCR:		19.7	WORK ORDE	R NON-CONFORMA	NCE (NCR	()			
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## Work Order ID 70820

Wednesday, June 15, 2011 2:27:53 PM

Item ID:

D3405-041

Revision ID:

Item Name:

Lug Assembly

Start Date:

6/15/2011

Start Qty: 12.00

Required Date: 6/22/2011

Req'd Qty: 12.00



Accept



Run

Setup Start



Stop

Cust Item ID:

Customer:

Reference:

Process Plan: Approvals:

OC:

Date:

Date:

Tooling:

SPC (Y/N):

Set Up/

Date:

Date:

Start

Stop

Sequence ID/ Work Center 1D

190

Quality Control

Operation Description

OC3- Inspect Part Finish

Memo

0.00

Run Hours

0.00

Tool ID

Tool# Plan Code

Accept Qty

Reject Qty

Number Stamp

Insp.

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

0.00

210

OC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/7/18 A)

W/O:			WO	RK ORDER CHANGE	ES				
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	A:	Date:	
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		A Part of the Part							

## **Picklist Print**

Wednesday, June 15, 2011 2:28:00 PM

Work Order ID: 70820

Parent Item:

D3405-041

Parent Item Name: Lug Assembly



Start Date: 6/15/2011

Required Date: 6/22/2011

Start Qty: 12.00

Required Qty: 12.00

Comments:

JPP A 05.09.01 New issue KJ/JLM

IPP B 09.01.28

rev.B drawing EC verified by:DD

Component	Item I	D/
Item Name		

Replacement Mfg/ Item ID

Purch

Manufactured

Purchased

Bin Primary Item Location

No

No

Last Location

Route Seq ID

100

Unit of Measure

Each

Qty on Hand

35.0000

Loc Code

Qty per Kit Total Oty

Qty Issued

Date Status Issued

Page 1

12

A 11-7-14

D3404-1

GHW Lug

70664 x 7

M304S11GA

304/316 0.125 Sheet

Location WA WA030

69883 67127

Loc Qty 32 32 3 sf 150

127.0000

0.154 

1.945263

1811-6-16

Loc Code Loc Qty Location 127 MAT020 127 117494

17444

W/O:			WC	RK ORDER CHANG	ES			
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	1							
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	lo DQA:	_ Date: _	
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	1	- 18						
	- 11							
					1			

DART AEROSPACE LTD	Work Order:	70820
Description: GHW Lug	Part Number:	D3405-1
Inspection Dwa: D3405 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

	×	X First Article			Prototype			
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments		
Ø0.438	+0.006/-0.001	,441	×		V BOL			
1.50	+/-0.030	1.500	15		V			
1.750	+/-0.010	1.751	~		V			
6.751	+/-0.010	6.752	X		V			
8.00	+/-0.030	8.001	7		V			
0.125	+/-0.010	1117	>		V			
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			-		-			
			-	+				
				-				
				_				
			-	-				
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				-				
				+				

Measured by:	B	Audited by:	Prototype Approval:	N/A
Date:	11-6-16	Date: 406/16	Date:	N/A

Rev	Date	Change	Revised by A	pproved
	100	New Issue P/O D3405-041	KJ/EC .	11
		Dimensions update per Dwg Rev. B	KJ/DD +	11
В	09.05.04	Dimensions apaate per bing from	7) 7	

Dail Aci	ospace	Liu							
W/O:			WO	RK ORDER CHANGE	S				
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		THE STATE OF THE S							
		211							

B QTY. DESCRIPTION QTY. ITEM PART NUMBER No. LUG ASSEMBLY D3405-041 X LUG ASSEMBLY D3405-043 X 2 GHW LUG D3404-1 11 GHW BRACKET D3405-1 12 GHW BRACKET D3405-3 13

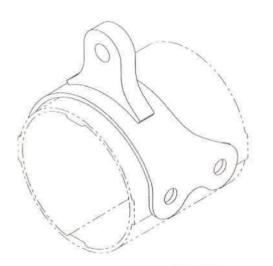
ENGINEER TO UNCONTROLLED TOPY SUBJECT TO AMESIZED (F) WITHOUT MATERIA WORK ORDER NO.\_Z2520

W11 26 15

SHEET STATE



D3405-041 LUG ASSEMBLY (SKID TUBE SECTION SHOWN FOR REF ONLY)



D3405-043 LUG ASSEMBLY (SKID TUBE SECTION SHOWN FOR REF ONLY)



D

DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERED TO "5" SZE BORDER FLAT PATTERNS FOR 1.6" 3. JINCREASED IN LENGTH TO PREVENT FOULING AT INST. (SEE PAR198), SMEETS 3.8.4 ZONE A.6.4 1.20 DIM WAS 4.100. AJS PH 05.03.08 NEW ISSUE A BY DATE DESCRIPTION REV. DART AEROSPACE LTD DESIGN HAWKESBURY, ONTARIO, CANADA DRAWN DRAWING NO. REV. B CHECKED D3405 SHEET 1 OF 4 MEG. APPR SCALE APPROVED GHW LUG ASSEMBLY NTS DE APPR COPYRIGHT & 2005 BY DART AFROSPACE LTD

HIS DOCUMENT S PRIVATE AND COMPOSITION AND IS INFORMATION OF EXPRESS CONFIDENCE ON COMPOSITION OF MATERIAL PRIVATE AND COMPOSITION OF COMPOSITION OF THE PRIVATE PRIVATE OF COMPOSITION OF COMPOSITION OF THE PRIVATE OF THE CONFIDENCE OF COMPOSITION OF THE PRIVATE OF THE CONFIDENCE OF COMPOSITION OF THE COMPOSITION O DATE 08.09.19

1) MATERIAL: N/A

8

D

1) MATERIAL: N/A
2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED

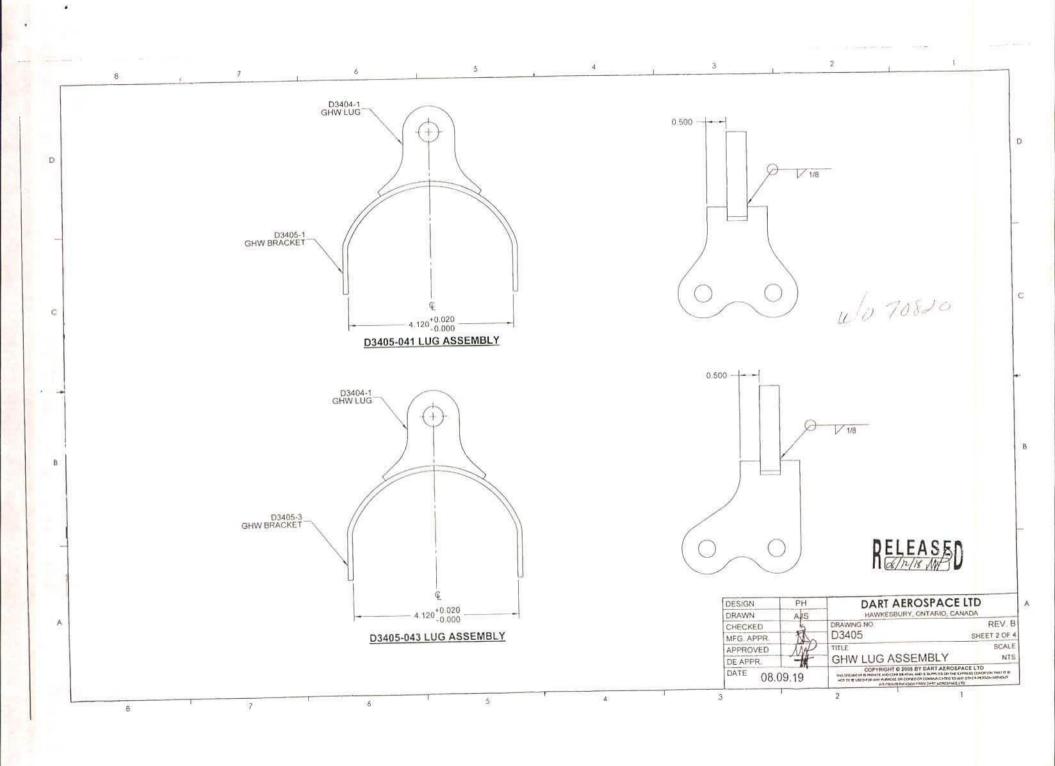
5) BREAK SHAPP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER: IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT: -041, 0.85 lbs -043, 0.87 lbs

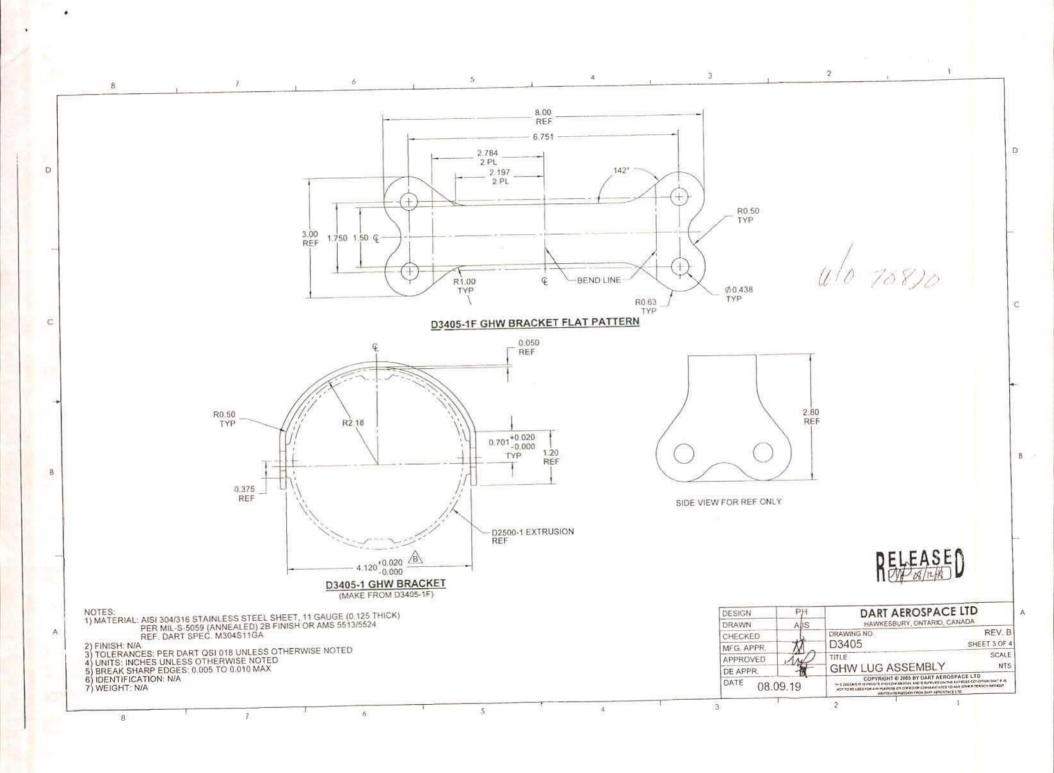
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08.09.19

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W/O:			WO	RK ORDER CHANGE	ES				
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DATE	CTED	Description of NC		Corrective Action Section	2011	Verific	ation	Approval	Approval
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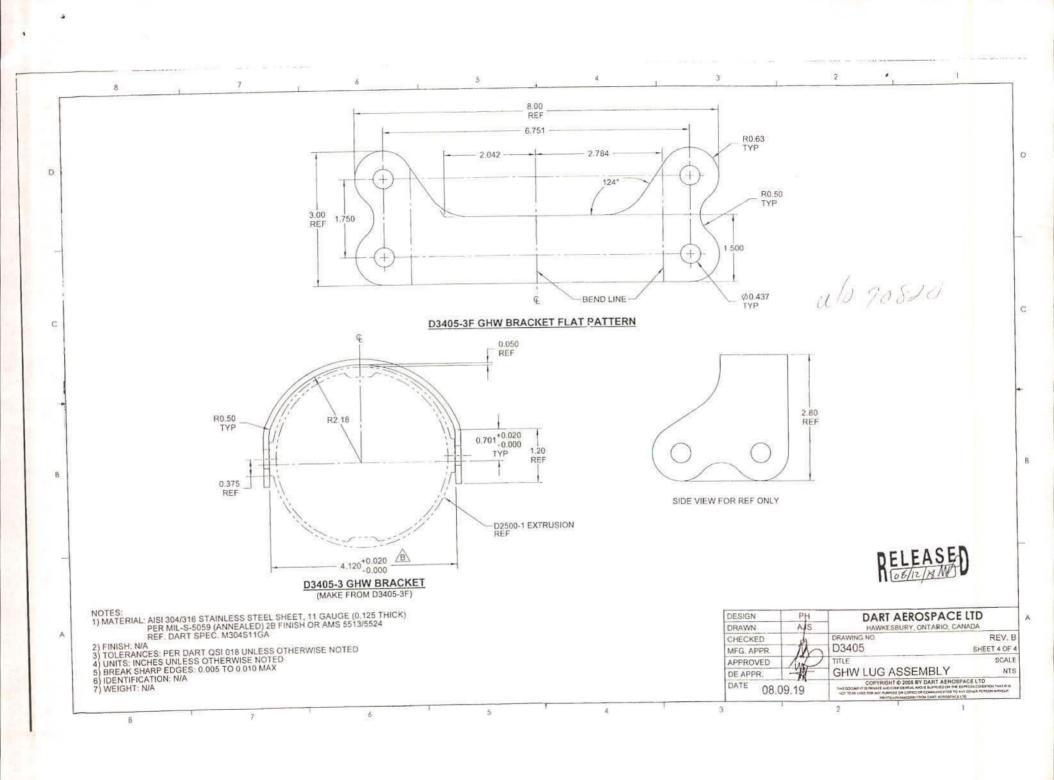


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W/O:			WC	RK ORDER CHANG	ES					
DATE	STEP	PROCEDURE CHANGE			В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:		PAR #:	Fault Category: NC			R: Yes No DQA: Date:				
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DATE	STEP	Description of NC Section A	Corrective Action Section B				Verification		Approval	Approval
DATE			Initial Chief Eng	Action Description  Chief Eng		ign & Date	Section C		Chief Eng	QC Inspector
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NOTE: Date & initial all entries



W/O:			WO	RK ORDER CHANG	ES					
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<sup>.</sup> NOTE: Date & initial all entries